

Work Order ID 151822

Tuesday, October 11, 2016 8:11:01 AM

151822

Page 1

Item ID: D4115-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Square Bracket, Litter Door

Start Date: 10/11/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/14/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

16-10-11

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4115	B

100

0.00

100

Waterjet

FLOW CNC Waterjet

Memo

0.00

1-Cut as per Dwg

Dwg Rev: BProg Rev: B

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

PR 16/10/11

1

1 PR 16/10/11

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation		Disposition			

Root Cause			FAULT CATEGORY		
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : ☐			
Misidentified ☐	Past Due ☐				

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Page 2

Item ID: D4115-3**Accept*****N900040100*****Setup Start*****NS1*****Revision ID:****Stop*****NS2*****Item Name:** Square Bracket, Litter Door**Start Date:** 10/11/2016 **Start Qty:** 1.00***1*****Cust Item ID:****Required Date:** 10/14/2016 **Req'd Qty:** 1.00***1*****Customer:****Reference:****Approvals:****Process Plan:** _____**Date:** _____**Tooling:** _____**Date:** _____**Run Start*****NR1*****QC:** _____**Date:** _____**SPC (Y/N):** _____**Date:** _____**Stop*****NR2*****Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

DAS
38
9-89
OCT 11 2016

140

Bend as per dwg

0.00

140

Brake NC

Memo

0.00

Brake NC

DAS
30
9-89

OCT 13 2016

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

DAS
38
9-89
OCT 13 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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						Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval					
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OTHER : ☐								

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Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

160

Identify as per dwg & Stock Location: 51084

0.00

160

Packaging

Memo

0.00

Packaging

) OCT 14 2016

DAS

6

9-89

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

DAS

21

9-89

OCT 14 2016

US 16/10/14

DAS

21

9-89

OCT 14 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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OTHER : ☐					

Picklist Print

Tuesday, October 11, 2016 8:11:06 AM

Page 1

Work Order ID: 151822

151822

Parent Item: D4115-3

D4115-3

Parent Item Name: Square Bracket, Litter Door

Start Date: 10/11/2016

Required Date: 10/14/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev:A 10.09.24 new issue DD verf:EC
10.12.03 as per dwg rev.B DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S14GA		Purchased		No		100	sf	15.4000	0.0185	0.019474			

M304S14GA

304SS sheet .080

PR 16/10/11

Location

Loc Qty

Loc Code

MAT019

15.4

M129972

5.7

M135061

3.8

M135689

5.9

0.02

DQA: _____ Date: _____

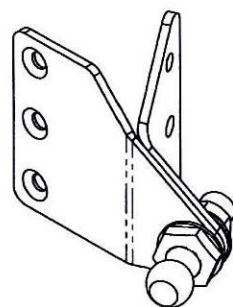


WORK ORDER NON-CONFORMANCE / UPDATE

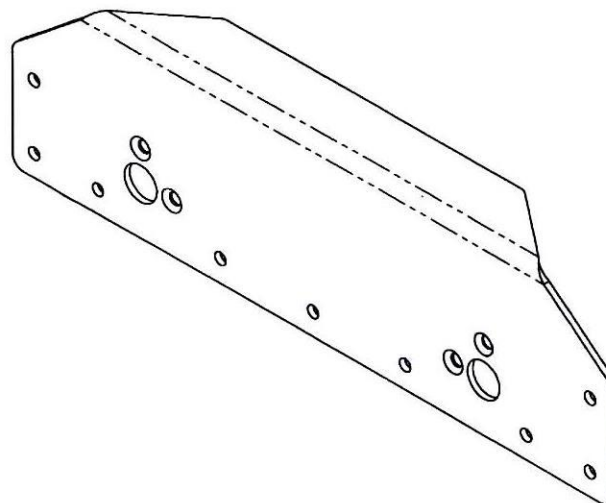
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D4115-041 LITTER DOOR BRACKET ASSY



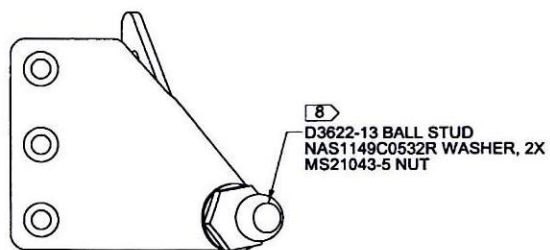
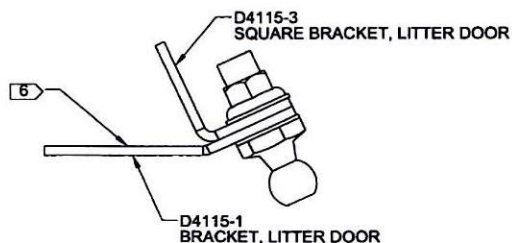
D4115-5 BRACKET, LITTER DOOR

*16-10-11
151822*

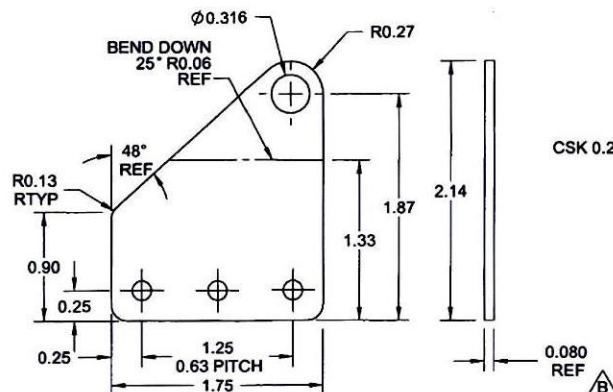
RELEASED
2010-11-30
MM

B	MATERIAL THK CHANGED FROM 0.063 TO 0.080	JPH	10.11.17
A	NEW ISSUE	JPH	10.07.20
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4115	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LITTER DOOR BRACKET	NTS
DATE	10.11.17	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

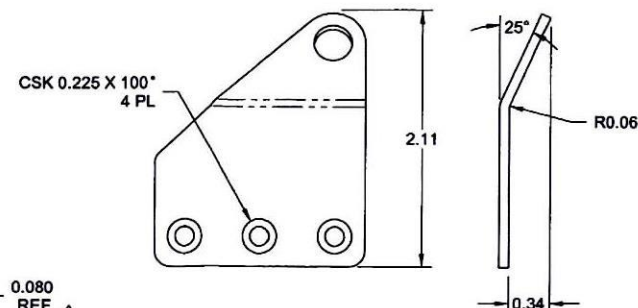
Qty -041	Part Number	Description
	D4115-041	LITTER DOOR BRACKET ASSY
1	D4115-1	BRACKET, LITTER DOOR
1	D4115-3	SQUARE BRACKET, LITTER DOOR
1	D3622-13	BALL STUD
2	NAS1149C0532R	WASHER
1	MS21043-5	NUT



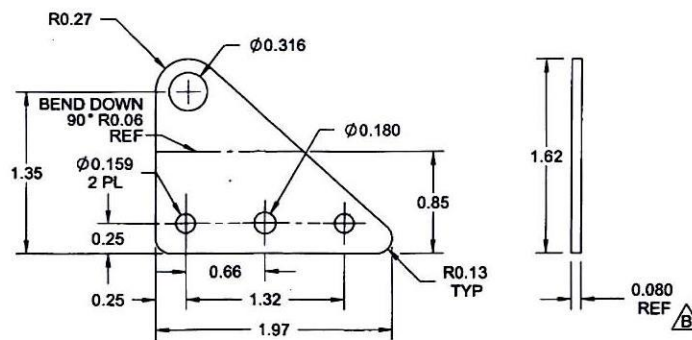
D4115-041 LITTER DOOR BRACKET ASSY



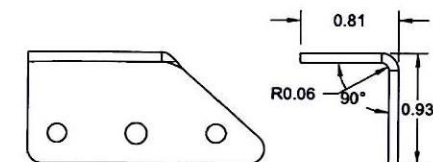
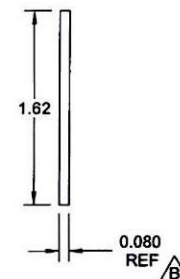
D4115-1F FLAT PATTERN, BRACKET, LITTER DOOR



**D4115-1 BRACKET, LITTER DOOR
(MAKE FROM D4115-1F)**



D4115-3F FLAT PATTERN, SQUARE BRACKET, LITTER DOOR



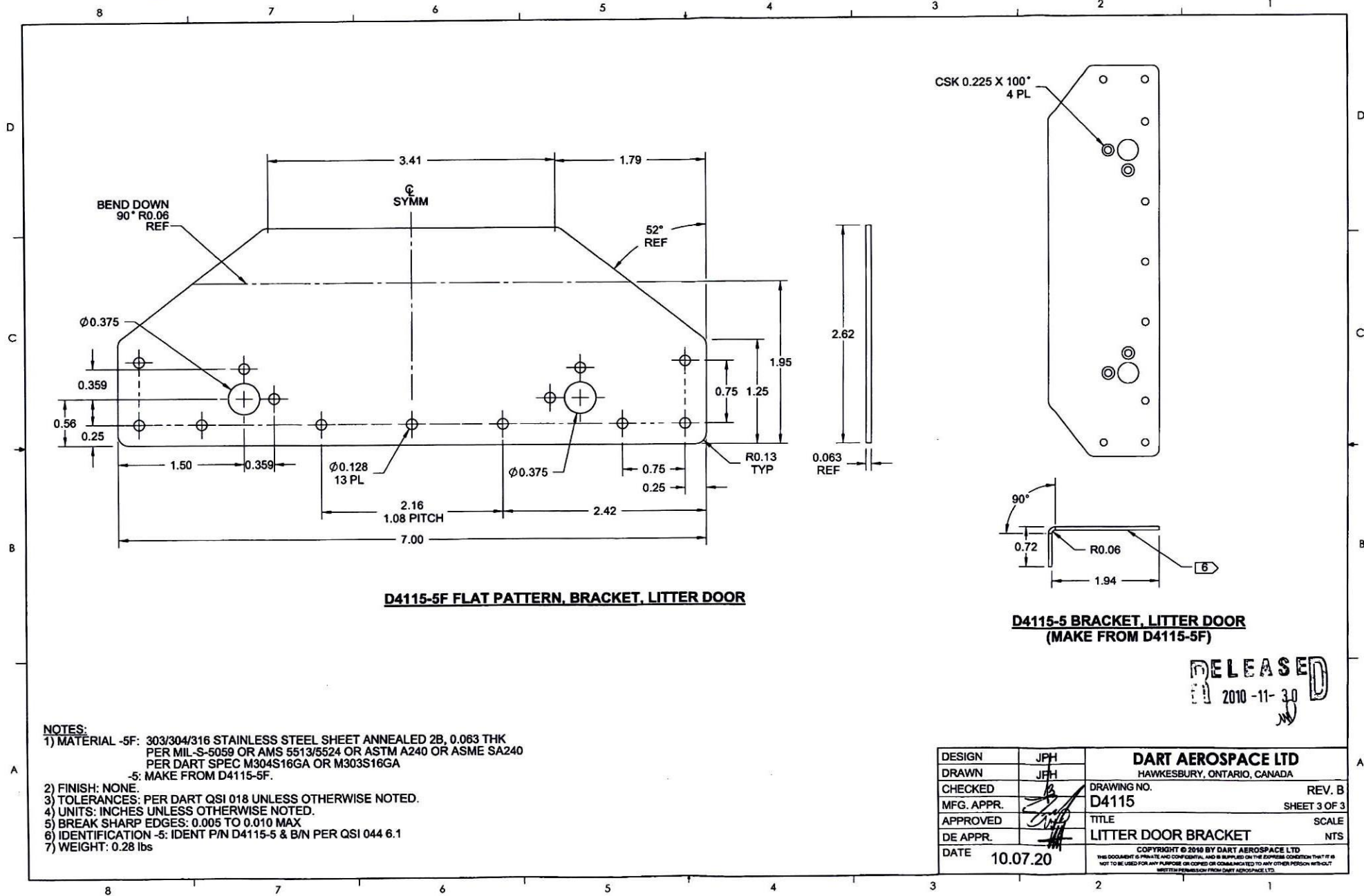
**D4115-3 SQUARE BRACKET, LITTER DOOR
(MAKE FROM D4115-3F)**

NOTES:

- 1) MATERIAL -1F & -3F: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.080 THK.
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
PER DART SPEC M304S14GA OR M303S14GA
-1: MAKE FROM D4115-1F.
-3: MAKE FROM D4115-3F.

- 2) FINISH: NONE.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION -041: IDENT P/N D4115-041 & B/N PER QSI 044 6.1
- 7) WEIGHT -041: 0.12 lbs
- 8) TORQUE TO 15 POUND INCH.

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO. D4115	REV. B
MFG. APPR.			SHEET 2 OF 3
APPROVED		TITLE LITTER DOOR BRACKET	SCALE NTS
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DATE	10.07.20		



D4115-5F FLAT PATTERN, BRACKET, LITTER DOOR

**D4115-5 BRACKET, LITTER DOOR
(MAKE FROM D4115-5F)**

RELEASED
2010-11-30

NOTES:

- 1) MATERIAL -5F: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.063 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
PER DART SPEC M304S16GA OR M303S16GA
-5: MAKE FROM D4115-5F.
- 2) FINISH: NONE.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION -5: IDENT P/N D4115-5 & B/N PER QSI 044 6.1
- 7) WEIGHT: 0.28 lbs

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4115	REV. B
MFG. APPR.	<i>[Signature]</i>	TITLE	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	LITTER DOOR BRACKET	SCALE
DE APPR.	<i>[Signature]</i>		NTS
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